

Work Order ID 154319

Thursday, December 08, 2016 11:15:25 AM

154319

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Item ID: D4149-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Plate, Aft
 Start Date: 1/10/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/11/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: DEC 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4149	C								

100 0.00
100
 Waterjet Memo 0.09
 FLOW CNC Waterjet Cut as per dwg D4149
 Prog Rev: C
 Dwg Rev: C
 OPEN TO HOLES TO FINISH SIZE AS PER DWG
 Deburr as required
 110 0.00
110
 QC Memo 0.01
 Quality Control

(4) _____ Dec 12/14

(4) _____ Dec 12/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 154319

Thursday, December 08, 2016 11:15:25 AM

154319

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Item ID: D4149-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Lug Plate, Aft

Start Date: 1/10/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/11/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

④ 16-221

DAS
9
9-89

150

Identify as per dwg & Stock Location: **81070A** 0.00***150***

Packaging

Memo

0.01

Packaging

411

JAN 03 2017

DAS
26
9-89

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.07

Quality Control

DAS
21
9-89

JAN 04 2017

DAS
21
9-89

JAN 03 2017

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐			
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐			
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐			
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐					
Date :		Step #:		QTY Effective :						MRB (QSI042) Approval			
Description Work Order Deviation				Disposition									
												Completed By	
												Lead hand / Supervisor Approval Verification	
												QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY									
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
OTHER :													

Picklist Print

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Work Order ID: 154319

154319

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 1/10/2017

Required Date: 1/11/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased			No	100	sf	57.8000	0.1355	0.570526			

M304S11GA

304/316 0.125 Sheet

Dec 16 / 12 / 14

Location

Loc Qty

Loc Code

MAT020

57.79998

M129545

0.00109

M135355

25.79889

M136327

32

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER : _____							

DART AEROSPACE LTD		Work Order: 154319
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø.128	/		V-D-01	
Ø0.191	+0.005/-0.001	Ø.190	/		Tap	
Ø0.257	+0.006/-0.001	Ø.256	/			
Ø0.38	+0.006/-0.001	Ø.38	/			
0.380	+/-0.010	.384	/			
0.469	+/-0.010	.468	/			
0.310	+/-0.010	.308	/			
0.750	+/-0.010	.749	/			
3.25	+/-0.030	3.25	/			
0.65	+/-0.030	.65	/			
0.63	+/-0.030	.63	/			
5.46	+/-0.030	5.46	/			
3.80	+/-0.030	3.80	/			
2.13	+/-0.030	2.13	/			
1.313	+/-0.010	1.314	/			
0.625	+/-0.010	.626	/			
0.375	+/-0.010	.382	/			
1.175	+/-0.010	1.180	/			
0.752	+/-0.010	.755	/			
1.588	+/-0.010	1.589	/			
1.587	+/-0.010	1.589	/			
11.15	+/-0.030	11.15	/			
0.750	+/-0.010	.759	/			
1.55	+/-0.030	1.55	/			
1.12	+/-0.030	1.12	/			
8.42	+/-0.030	8.42	/			
2.70	+/-0.030	2.70	/			
0.125	+/-0.010	.116	/			
Ø0.252	+0.003/-0.000	Ø.252	/			

Measured by: <u> </u>	Audited by: <u>DAS 9</u>	Preliminary Approval: <u> </u>
Date: <u>16/12/19</u>	Date: <u>9-89/16.12.21</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

